



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3914-041

Job Sheet 170371



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 2/19/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/17/18	2/17/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-2-14
100	Large Fab	1 pcs	2/17/18	2/17/18	0.00	6.67	Large Fab 1		C.C 18-2-16
110	QC	1 pcs	2/17/18	2/17/18	0.00	0.00	QC9		CPC
120	QC	1 pcs	2/17/18	2/17/18	0.00	0.00	QC5		CPC
130	Powdercoat	1 pcs	2/17/18	2/17/18	0.00	0.40	Powdercoat4		BR 18-2-16
135	QC	1 pcs	2/17/18	2/17/18	0.00	0.00	QC3		BEB 18-02-16
140	HandFinish	1 pcs	2/19/18	2/19/18	0.00	0.80	HandFinish3		BEB 18-02-16
150	QC	1 pcs	2/19/18	2/19/18	0.00	0.00	QC3		W 18-2-20
160	Packaging	1 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3-2		KL 18-2-16
170	QC21-SA	1 Ea	2/19/18	2/19/18	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 138900. START: 0:00 OUT: 3:30 FINISH: 0:30.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5033599	2	18	0	0
	D3914-1 5034699	2	9	0	0
	D3914-7 5032228	2	22	0	0
	D4016-3 5038793	3	25	0	0
	D4018-5 5039656	9	45	0	0
	D4020-5 5040304	1	8	0	0
	D4021-3 5032432	1	2	0	0
	D4035-043 5041480	2	2	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	

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Container No: S042391

Part: D3914-041

Serial No/Batch: S042391

Revision: D4020, D3914

Inspector:

Date: 02/14/18 13:47 PM

Environm

De:

Doc/L

Equip/Too

Handling

Matr

Internal Trans

Tribal Knowledge

LOA

Substation

Past Expiry Date

Misidentified

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heat Treat

Wave/Twist in Tube

Marks/Chatter

OTHER :

Master Unit 000610

Job No 170371